

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002435**Date Inspected:** 14-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:**

Yes No

Inspected CWI report: Yes No N/A**Rod Oven in Use:**

Yes No N/A

Electrode to specification: Yes No N/A**Weld Procedures Followed:**

Yes No N/A

Qualified Welders: Yes No N/A**Verified Joint Fit-up:**

Yes No N/A

Approved Drawings: Yes No N/A**Approved WPS:**

Yes No N/A

Delayed / Cancelled:

Yes No N/A

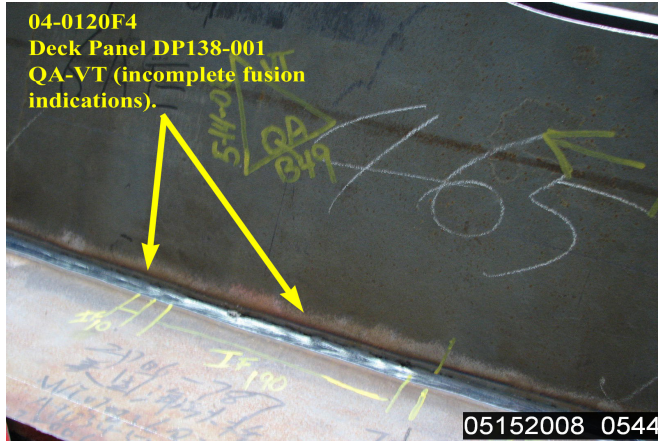
Bridge No: 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M, Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Deck Panel	NA	NA	QA-VT
<p>OBG Bay 1- Caltrans QA Inspector performed a Quality Assurance visual weld inspection on Orthotropic Box Girder (OBG) Deck Panel Assembly identified as DP383-001, partial joint penetration (PJP) welds 002 through 008 and DP435-001, PJP welds 002 through 009 joining u-ribs to deck plate. QA Inspector observed various defects which include oversize weld, overlap, underfill, undercut and incomplete fusion. The length and the location of each of these areas were recorded on the Caltrans QA Visual Weld Inspection Report for the Orthotropic Box Girder (OBG) and Deck Panel for tracking and distributed to the appropriate personnel for review. The following digital pictures illustrate deck panel DP138-001 and typical markings, identifying weld indications.</p>				

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



2 Bottom Plate NA NA QA Radiographic Film R

Radiographic Film Review: Caltrans QA Inspector reviewed radiographic film for deck panels BP034-001-049, BP061-001-049 and BP169-001-049. See Caltrans Radiographic Film Review (TL-6029), dated May 14, 2008 for additional information.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
